

Work Order ID 84808

84808

Page 1

May-23-12 11:33:10 AM

Item ID: D2721-042
Revision ID:
Item Name: 206B Step Assembly

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 23/05/2012 Start Qty: 4.00
Required Date: 06/06/2012 Req'd Qty: 4.00

4
4

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/23 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2721	Rev C								

100 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2721-2 using D2622 extrusion as per Dwg D2721
Deburr and bevel ends for welding

4 0 Ac
12.06.12.

110 0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT
followed by Jig DT

A/R AL Rod Batch: 120854
122130

Grind end cap welds flush

4 0 Ac
12.06.20

4 0 Ac
12.06.20

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0	BE	12/06/26
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		512/06/26		74 R7			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	26	126	27

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Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				4	0		12.06.27
150									
QC	Memo	0.00							
Quality Control									
160		0.00				4	0		12.06.27
160	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Inspect for foreign object per QSI 024								12.07.03
	Weld Remaining end cap as per Dwg D2721								
	A/R AL Rod Batch: 120854								
	Grind End Cap Welds Flush								
170	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
170									
QC	Memo	0.00							
Quality Control									

502 107103

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Stop *NS2*

Start Date: .23/05/2012 **Start Qty:** 4.00
Required Date: 06/06/2012 **Req'd Qty:** 4.00

4

Cust Item ID:
Customer:

4

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180 QC5- Inspect part completeness to step on W/O

0.00

0.00

180

QC

Quality Control

Memo

190 Chemical Conversion Coat per QSI005 4.1

0.00

190

HandFinish

Hand Finishing

Memo

0.00

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

$$\begin{array}{r} 7215 \\ \times 320 \\ \hline 14430 \\ 144300 \\ \hline 2308800 \end{array}$$

4 96 12-7.3

4X ~~✓~~ _____ M-L
12/07/04

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210 QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

4 2 20/BR 12/07/04

220

Wing Walk as per dwg QSI005 4.4 Batch 2463

0.00

220

HandFinish

Memo

0.00

Hand Finishing

4 2 20 12/07/04

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

12/2/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 6

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Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo <i>Pls 84808</i>	0.00							<i>(y)</i>
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							<i>12/7/11</i>
Quality Control									

2007-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May-23-12 11:33:14 AM

Page 1

Work Order ID: 84808

84808

Parent Item: D2721-042

D2721-042

Parent Item Name: 206B Step Assembly

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing
walk DD 10.02.24 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	35.6100	1	4			

D2622-120C

Step Extrusion

**

B83894 (4) Ae ~~12.06.12~~
12.06.12

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	9.88	
81507	9.88	
WA013	9.36	
75781	2	
77612	7.36	

D2734

Manufactured No

110

Each

51.0000

1

4

D2734

Step End Plate

**

12-09-20

Location	Loc Qty	Loc Code
WA	51	
76985	5	
80682	16	
83322	30	

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 84808

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Parent Item: D2721-042

D2721-042

Parent Item Name: 206B Step Assembly

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

D3461-1 Manufactured No

110 Each

45.0000 1 4

D3461-1

Mounting Plate

**

12.06.27

Location

Loc Qty

Loc Code

WA003

45

58756

45

D3461-3 Manufactured No

110 Each

2.0000 1 4

D3461-3

Mounting Plate

**

12.06.27

Location

Loc Qty

Loc Code

WA017

2

41601

2

D3461-5 Manufactured No

110 Each

18.0000 1 4

D3461-5

Mounting Plate

**

12.06.27

Location

Loc Qty

Loc Code

WA017

18

33862

18

D3461-7 Manufactured No

110 Each

20.0000 1 4

D3461-7

Mounting Plate

**

12.06.27

Location

Loc Qty

Loc Code

WA017

20

33863

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D2721-042

D2721-042

Parent Item Name: 206B Step Assembly

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

D2734

Manufactured No

160

Each

51.0000

1

4

D2734

Step End Plate

**

12.06.28

Location

Loc Qty

Loc Code

WA

B84563

51

76985

5

80682

16

83322

30

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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RELEASED
05-11-14
H

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2721-1
MAKE FROM EXTRUSION D2622-078

D2721-041 LH STEP ASSEMBLY (SHOWN)
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
		D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
 2) WELD PER DART QSI 004
 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 4) ALL DIMENSIONS ARE IN INCHES
 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 12/05/23
TYPICAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84808

NO. 84808 MLJ

12/05/23

TYPICAL STEP END DETAIL

В

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